

Date: Wednesday, 4/4/2007 9:03:32 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET HINGE
Job Number	: 31608		
Estimate Number	: 10587		
P.O. Number	: <u>N/A</u>	Part Number	: D22321
This Issue	: 4/4/2007 S.O. No. : <u>N/A</u>	Drawing Number	: D2232 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 29535	Material	: <u>N/A</u>
Written By	: <u>07.04.04</u>	Due Date	: 4/30/2007 Qty: 50 Um: Each
Checked & Approved By	: <u>07.04.04</u>		
Comment	: Est.B 01/06/07 Now laser cut EC Est Rev:C Now on Waterjet 06-11-21 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.0255 sf(s)/Unit Total : 1.2758 sf(s)  
 304/316 .125 Sheet

ml  
1102807

07/04/25 (50)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET  
 1-Cut as per Dwg D2232  
 Dwg Rev: C  
 Prog Rev: C

2-Deburr if necessary

ml  
07/04/25 (50)  
07/05/03 (49)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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ml  
07/04/25

(50)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/04/26 (50)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock  
 Location: WS

07/05/08 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: PA Date: 07/05/08  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:03:32 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET HINGE

Job Number: 31608

Part Number: D22321

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

Lot 105108

Job Completion



Lot 105108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

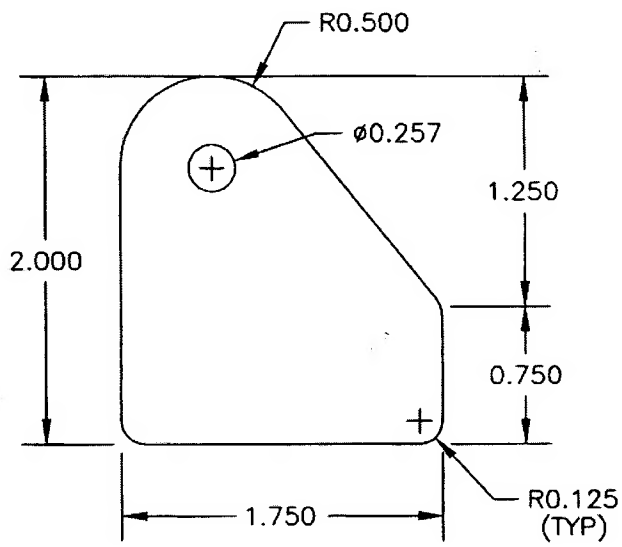
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

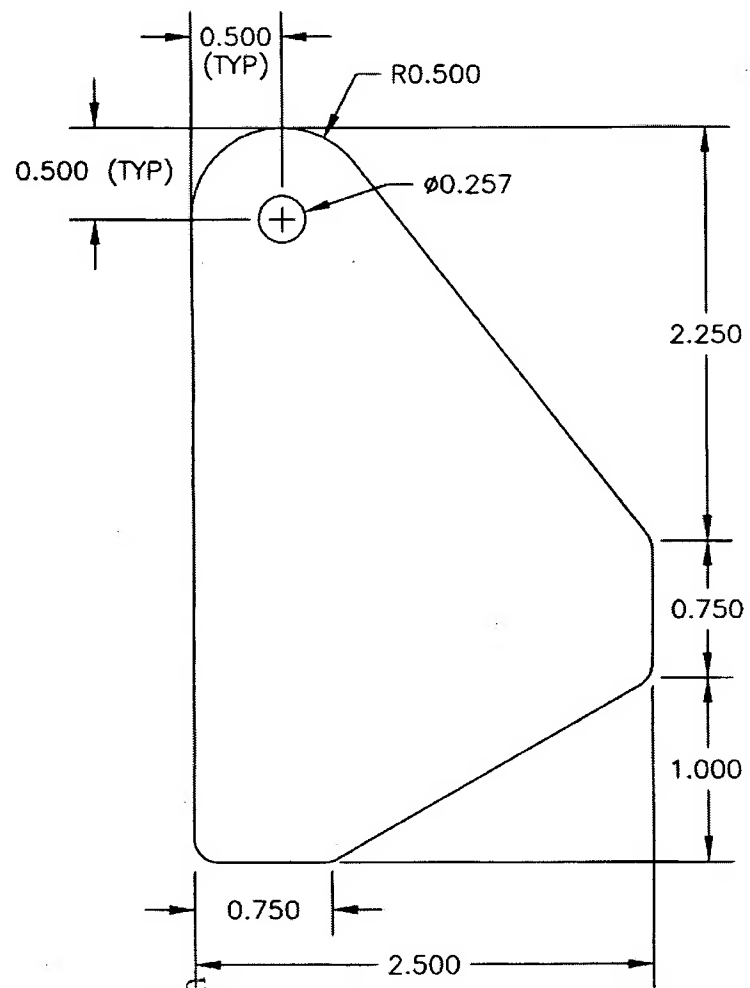


RELEASED  
98.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. C
CHECKED	APPROVED	DRAWING NO.	D2232	SHEET 1 OF 2
DATE		TITLE	BASKET HINGE	SCALE
98.04.28				1:1
A	94.05.12	NEW ISSUE		
B	96.01.02	ADDED -5 AND -7		
C	98.04.28	0.125 THICK WAS 0.063		



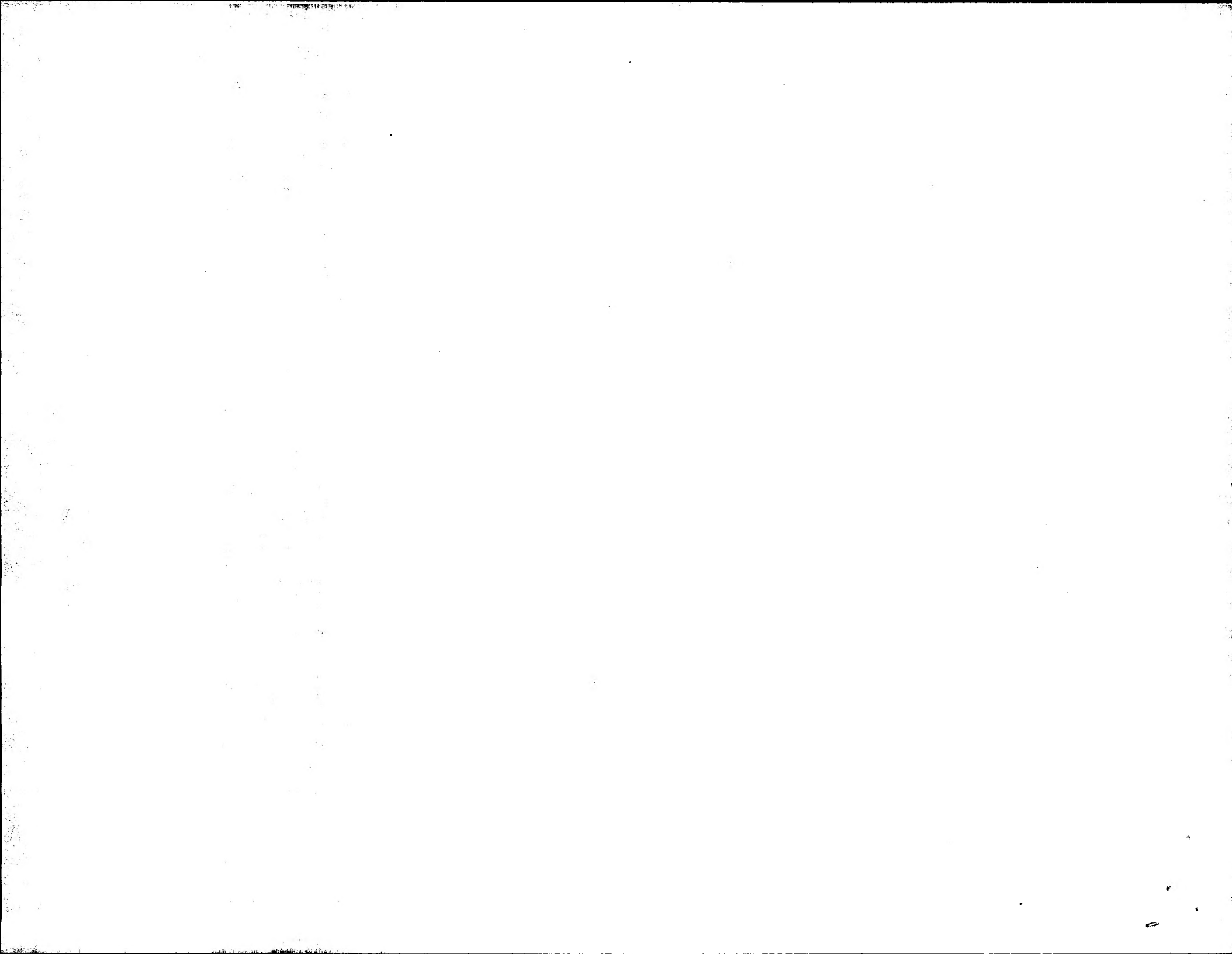
D2232-1



D2232-3

MATERIAL: AISI 304/316 SS 0.125 THICK

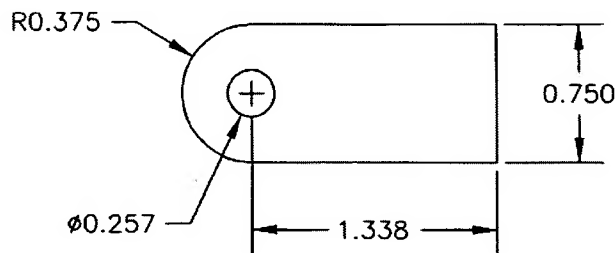
SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 31608



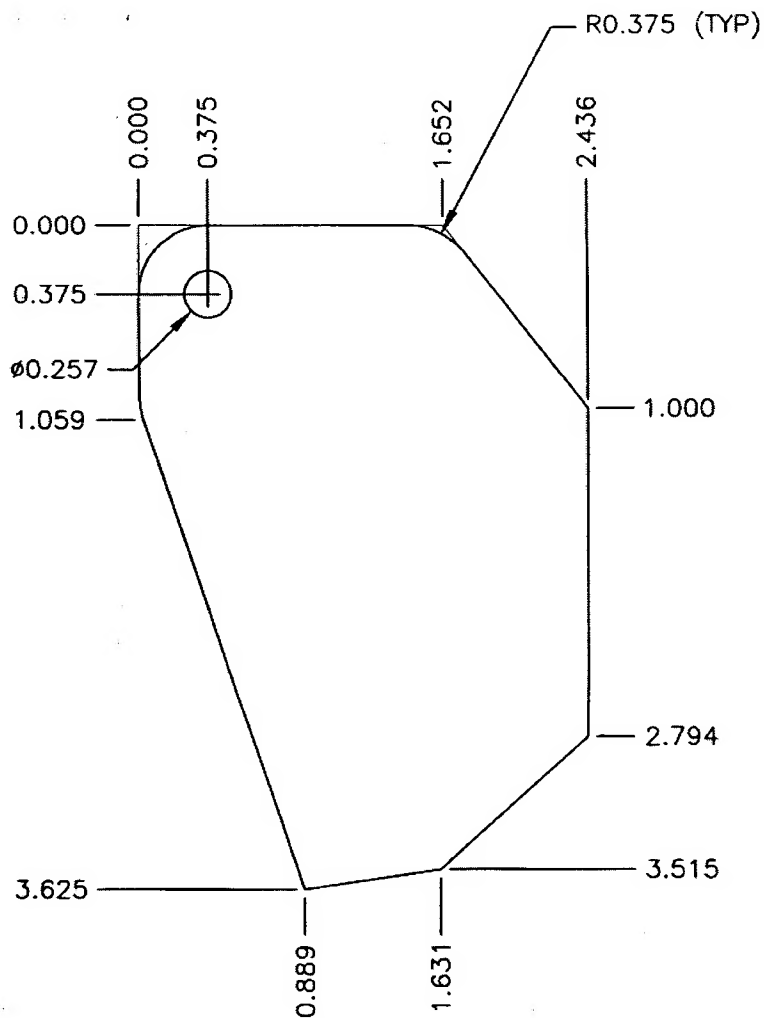


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE		D2232	SHEET 2 OF 2
98.04.28		TITLE	SCALE
		BASKET HINGE	1:1

RELEASED  
98.05.05 KE



D2232-7



D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

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WORK ORDER  
NO 31608





DART AEROSPACE LTD		Work Order: 31608
Description: Basket Hinge		Part Number: D2232-1
Inspection Dwg: D2232 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.257$	+0.006-0.001	0.257	✓		VERN	
E 1.750	+/- 0.010	1.755	✓		VERN	
C 0.750	+/- 0.010	0.750	✓		VERN	
D 2.000	+/- 0.010	2.000	✓		VERN	
E R0.125	+/- 0.010	R0.125	✓		Radius Gauge	
F R0.500	+/- 0.010	R0.500	✓		Radius Gauge	
G 1.250	+/- 0.010	1.250	✓		Height Gauge	
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>MM. MM</i>	Audited by: <i>DA</i>	Prototype Approval:	N/A
Date: 07.04.25	Date: 07/04/26	Date:	N/A
Rev	Date	Change	Revised by KJ/RF
		New Issue	Approved

